

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021708**Date Inspected:** 25-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Zhan Yuan Yuan, CWI Luli Ging.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13 E

PCMK: SEG3007C

Weld No: 262

Welder: 050262

WPS-B-T-2233-ESAB

Components; OBG 13BE

PCMK: SEG3009G

Weld No: 006

Welder: 037705

WPS-B-T-2232-ESAB

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Components; OBG 13CE

PCMK: SA3214A-001

Weld No: 009

Welder: 070254

WPS-B-T-2233-ESAB

Components; OBG 13CE

PCMK: DP3104-001

Weld No: 253,256

Welder: 044790

WPS-B-T-2233-ESAB

Components; OBG 13 E

PCMK: SEG3007M

Weld No: 004

Welder: 055564

WPS-B-T-2233-ESAB

Components; OBG 13 E

PCMK: SEG3007D

Weld No: 231

Welder: 055491

WPS-B-T-2233-ESAB

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Zhan Yuan Yuan, CWI Luli Ging.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13E

PCMK: SEG3007F

Weld No: 006

Welder: 216086

WPS-B-P-2213-B-U2-FCM-1

Components; OBG 14E

PCMK: SEG3019P

Weld No: 172, 177

Welder: 066418

Weld Repair No. B-WR20247

WPS-345-SMAW-3G(3F)-FCM-Repair-1

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Components; OBG 14E
PCMK: SEG3019M
Weld No: 093, 098
Welder: 054013
Weld Repair No. B-WR20248
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Components; OBG 14E
PCMK: SEG3019R
Weld No: 146
Welder: 067610
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG 13E
PCMK: SEG3019R
Weld No: 147
Welder: 067610
WPS-B-P-2214-B-U2-FCM-1

Components; OBG 14E (see picture below)
PCMK: DP3167-001
Weld No: 022
Welder: 050969
Weld Repair No. B-WR20250
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14E
PCMK: DP3167-001
Weld No: 246,
Welder: 215553
Weld Repair No. B-WR20271
WPS-345-SMAW-2G(2F)-FCM-Repair-1

Components; OBG 14E (see photo below)
PCMK: DP3160-001
Weld No: 219
Welder: 067656
Weld Repair No. B-WR20272
WPS-345-SMAW-2G(2F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Bay 14.
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Li Ping, CWI An Qing Xiang.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

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Listed below are the locations that were identified by this QA inspector.

Components; OBG 14W
PCMK: SEG3020AP
Weld No: 014
Welder: 067764, 066038
WPS-B-P-2214-TC-U4b-FCM-1

Components; OBG
PCMK: SEG3014B
Weld No: 007
Welder: 045213
WPS-B-P-2213-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Ping, CWI An Qing Xiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 14 W
PCMK: SEG3020BB
Weld No: 111
Welder: 067949
WPS-B-T-2233-ESAB

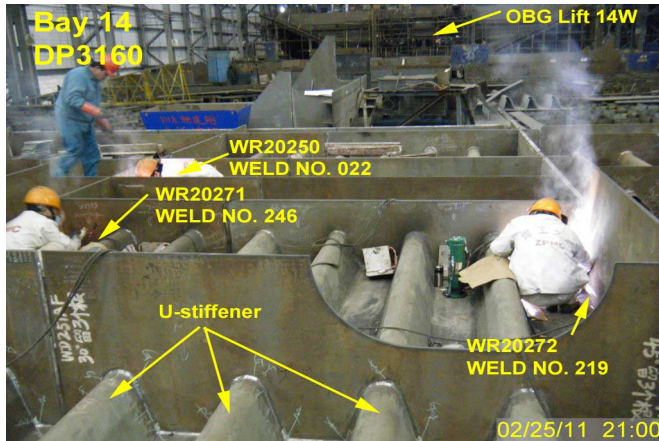
Components; OBG 13AW
PCMK: SEG3013F
Weld No: 019
Welder: 066421
WPS-B-T-2232-ESAB

Components; OBG 13AW
PCMK: SEG3013G
Weld No: 023
Welder: 067876
WPS-B-T-2232-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By: Leavitt, Kelly

Quality Assurance Inspector

Reviewed By: Riley, Ken

QA Reviewer